



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D119-796-025
Job Sheet 182451



Part No: D119-796-025

Job Qty: 1 ea

Part Name: AW119 Landing Gear Assembly - Heavy-Duty, Run-on Landing Wearplates



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/24/18

Job Tracking No:

Due Date: 10/10/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D119-796-025 REV A, IIN-D119-796 REV F IPP REV:A 15.08.25 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/10/18	10/10/18	0.00	0.00	Start Up Stores/Pkg-1		SEP 28 2018
100	Packaging	1 pcs	10/10/18	10/10/18	0.00	0.00	Packaging1-1		SEP 28 2018
110	HandFinish	1 pcs	10/10/18	10/10/18	0.00	8.33	HandFinish4		
120	QC	1 pcs	10/10/18	10/10/18	0.00	0.00	QC5		
125	Packaging	1 pcs	10/10/18	10/10/18	0.00	0.00	Packaging1-1		
127	QC	1 pcs	10/10/18	10/10/18	0.00	0.00	QC4		
130	Packaging	1 pcs	10/10/18	10/10/18	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea	10/10/18	10/10/18	0.00	0.00	QC21		

Part Op 100 - Photocopy bluefile and create labels as per PPP D119-796-025 chg 003/ D119-646-241 paperwork
Descriptions: 110 - ASSEMBLE AS PER DWG AND NOTES 8,9,10,11
130 - Identify and pack for shipping as per PPP D119-796-025

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C46A	Bolt	8 Ea (8 ea)	90-Start up Operation	5024836
AN3C50A	Bolt	16 Ea (16 ea)	90-Start up Operation	5082906
AN4C6A	Bolt	24 Ea (24 ea)	90-Start up Operation	5076002
D2652	Bushing	48 Ea (48 ea)	90-Start up Operation	5097682
D3407-041	Tow Ring	2 Ea (2 ea)	90-Start up Operation	5104544
D3417-5	Washer	4 Ea (4 ea)	90-Start up Operation	5089810
D3456-1	Washer	2 Ea (2 ea)	90-Start up Operation	5079335
D3672-3	Washer, Phenolic	48 Ea (48 ea)	90-Start up Operation	5027022
D3672-7	Washer, Phenolic	48 Ea (48 ea)	90-Start up Operation	5157442
D3883-1	Saddle, Outboard LH	2 Ea (2 ea)	90-Start up Operation	5102075X1
D3883-2	Saddle, Outside RH	2 Ea (2 ea)	90-Start up Operation	5102810X1 51027

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Not Approved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐			
Date :		QTY Effective :		MRB (QSI042) Approval			
Description Work Order Revision		Disposition		Completed By			
Container No: S114332 Part: D119-796-025 Job No: 182451 Serial No/Batch: S114332 Revision: A / F Inspector: _____ Exp Date: _____ Instructions: TC STC SH14-45 - issued, FAA STC SR03504NY 15/01/28, EASA				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			
Environment Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Loading ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Misabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐		FAULT CATEGORY			
Other : _____							

D3884-1	Saddle, Inside LH	2 Ea (2 ea)	90-Start up Operation	5103378	
D3884-2	Saddle, Inside RH	2 Ea (2 ea)	90-Start up Operation	5104414	
D3886-041	Lug Assembly	4 Ea (4 ea)	90-Start up Operation	5089982x2	580520x2
MS21043-3	Nut	24 Ea (24 ea)	90-Start up Operation	5083543	
MS21043-4	Nut	26 Ea (26 ea)	90-Start up Operation	5089277	
MS21043-5	Nut	8 Ea (8 ea)	90-Start up Operation	5083544	
MS21250-05048	Bolt (Use Ms21250-05-048)	8 Ea (8 ea)	90-Start up Operation	5058168x1	5093780x7
NAS1149C0332R	Washer	24 Ea (24 ea)	90-Start up Operation	504354	
NAS1149C0432R	Washer	48 Ea (48 ea)	90-Start up Operation	5050052	
NAS1149C0532R	Washer	16 Ea (16 ea)	90-Start up Operation	5089242	
D119-646-241	AW119 Replacement Skidtube with Heavy Duty Wearplates - Fits LH or RH	2 Ea (2 ea)	110-HandFinish	5059730	
D119-796-151	Fwd Crosstube Installation With Step (No Hardware)	1 Ea (1 ea)	110-HandFinish	5059716	
D119-796-251	Aft Crosstube Installation With Step (No Hardware)	1 Ea (1 ea)	110-HandFinish	5116558	
MS21920-28	Clamp	2 Ea (2 ea)	125-Packaging	5116578	
				5093575	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C46A	8	160	0
	AN3C50A	16	215	0
	AN4C6A	24	601	0
	D2652	48	607	0
	D3407-041	2	19	0
	D3417-5	4	31	0
	D3456-1	2	240	0
	D3672-3	48	851	0
	D3672-7	48	379	0
	D3883-1	2	15	0
	D3883-2	2	15	0
	D3884-1	2	21	0
	D3884-2	2	24	0
	D3886-041	4	24	0
	MS21043-3	24	1,103	0
	MS21043-4	26	1,277	0
	MS21043-5	8	228	0
	MS21250-05048	8	25	0
	NAS1149C0332R	24	6,494	0
	NAS1149C0432R	48	2,987	0
110-HandFinish	NAS1149C0532R	16	323	0
	D119-646-241	2	4	0
	D119-796-151	1	1	0
125-Packaging	D119-796-251	1	0	0
	MS21920-28	2	80	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					